

Work Order ID 54450

December 9, 2009 11:30:45 AM

Page 1

Item ID: D3276-042
Revision ID:
Item Name: Baffle Assembly RH

Accept

Setup Start

Stop

Start Date: 09/12/2009 Start Qty: 4.00

Required Date: 16/12/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3276

Rev B

100

0.00

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3276 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

0.00

18 9-12-10

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

18 9-12-10

120

QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

2) S 02/12/11

(16) 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab Memo 1-Deburr□2-Roll as per Dwg D3276	0.00 0.00	SB 09/12/16			6	0		
140 Brake NC	NC BRAKE Memo Form as per Dwg D3276	0.00 0.00	SB 09/12/16			6	0		
150 QC	QC5- Inspect part completeness to step on W/O Memo Quality Control	0.00 0.00	⇒ S 09/12/16			(46)	0		

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Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

UMD 09/12/17

x6

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:00
372° FINISH TIME:

OVEN TEMPERATURE:

12:30

BR 09-12-17

6

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

=> M 09-12-17

x6

Quality Control

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3276								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
210 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

ES 09/12/22 (6)

ES 09/12/22 (6)

PC 10/01/14 (6)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

PA 10-1-04
AL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 54450

Parent Item: D3276-042

Parent Item Name: Baffle Assembly RH

Start Date: 09/12/2009


Required Date: 16/12/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3276-3		Manufactured	No			110	Each	7.0000	4.0000			
												
Decal												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST78

7

52913

7

D2464		Manufactured	No			190	f	742.9610	9.0000			
												
3/4 Seal												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

742.9609737

39669

89.87

48173

653.090974

CP 509/2/22

CP 509/2/22

✓

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 16/12/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Row Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040 		Purchased	No			190	sf	216.9102	4.2968	6.5		
6061-T6 .040 Sheet											12-9-10	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	216.9102	
100742	3.3	
102723	5.93	
105842	12	
106747	5.7516	
107461	11.7841	
109396	17.9316	
111224	23.0629	
113004	135.65	
19380	1.5	

6

113004

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